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D3488-4

Job Sheet 198543



Part No: D3488-4

Job Qty: 12 pcs

Part Name: Blade Fitting, RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/30/19

Job Tracking No:

Due Date: 8/30/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DSK101 REV.D / D3488 REV.C IPP REV:A 18.11.09 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Doosan - 1	12 pcs		8/30/19	1.00	10.55	Doosan - 1		19/08/02
110	QC 2	12 pcs		8/30/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

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						QC 2 - 65	11/08/02
						QC 2 - 5	
						QC 2 - 71	
						QC 2 - 73	
						QC 2 - 69	
120 HAAS 4 Axis - B4B	12 pcs	8/30/19	1.00	8.23	HAAS - 1 - B4B		
					HAAS - 2 - B4B		
					HAAS - 3 - B4B		
					HAAS - 4 - B4B		
130 QC 2	12 pcs	8/30/19	0.00	0.00	QC 2 - 1		mm L 19/09/23
					QC 2 - 12		
					QC 2 - 14		
					QC 2 - 17		
					QC 2 - 19		
					QC 2 - 2		
					QC 2 - 20		
					QC 2 - 22		
					QC 2 - 23		
					QC 2 - 25		
					QC 2 - 32		
					QC 2 - 33		
					QC 2 - 35		
					QC 2 - 39		
					QC 2 - 4		
					QC 2 - 40		
					QC 2 - 44		
					QC 2 - 45		
					QC 2 - 48		
					QC 2 - 49		mm L 19/09/23
					QC 2 - 50		
					QC 2 - 51		
					QC 2 - 52		
					QC 2 - 57		
					QC 2 - 62		
					QC 2 - 63		
					QC 2 - 8		
					QC 2 - 66		
					QC 2 - 64		
					QC 2 - 65		
					QC 2 - 5		
					QC 2 - 71		
					QC 2 - 73		
					QC 2 - 69		
140 QC 8	12 pcs	8/30/19	0.00	0.00	QC 8 - 12		mm L 19/09/25
					QC 8 - 14		
					QC 8 - 17		
					QC 8 - 20		
					QC 8 - 25		
					QC 8 - 3		
					QC 8 - 32		
					QC 8 - 33		
					QC 8 - 35		
					QC 8 - 39		
					QC 8 - 4		
					QC 8 - 44		
					QC 8 - 45		
					QC 8 - 49		
					QC 8 - 58		
					QC 8 - 8		

					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
					150 Handfinish - 1-1 Chemical-B4B	12 pcs
Handfinish - 1 - 2 - B4B						
Handfinish - 1 - 3 - B4B	SEP 25 2019					
Handfinish - 1 - 4 - B4B						
Handfinish - 1 - 5 - B4B						
Handfinish - 1 - 6 - B4B						
Handfinish - 1 - 7 - B4B						
Handfinish - 1 - 8 - B4B						
Handfinish - 1 - 9 - B4B						
Handfinish - 1 - 10 - B4B						
Handfinish - 1 - 11 - B4B						
Handfinish - 1 - 12 - B4B						
Handfinish - 1 - 13 - B4B						
Handfinish - 1 - 14 - B4B						
Handfinish - 1 - 15 - B4B						
Handfinish - 1 - 16 - B4B						
Handfinish - 1 - 17 - B4B						
Handfinish - 1 - 18 - B4B						
Handfinish - 1 - 19 - B4B						
Handfinish - 1 - 20 - B4B						
Handfinish - 1 - 21 - B4B						
Handfinish - 1 - 22 - B4B						
160 Powdercoat - 1 White GI(A)-B4B	12 pcs	8/30/19	0.00	0.42	Powdercoat - 1 - B4B	
					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	BK 19-9-24
					Powdercoat - 4 - B4B	
170 QC 3	12 pcs	8/30/19	0.00	0.00	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					Plex 7/30/19 2:47 PM Dart.lajeunesse.marie	

				Packaging 3 - 28 - B4B		
				Packaging 3 - 29 - B4B		
				Packaging 3 - 30 - B4B		
				Packaging 3 - 31 - B4B		
				Packaging 3 - 32 - B4B		
				Packaging 3 - 33 - B4B		
				Packaging 3 - 34 - B4B		
				Packaging 3 - 35 - B4B		
				Packaging 3 - 36 - B4B		
210 QC 21 - SA	12 pcs	8/30/19	0.00	0.00	QC 21 - SA - 21	DAS
					QC 21 - SA - 70	SEP 25 2019 70
					QC 21 - SA - 53	9-89

Part Op 100 - Doosan (Doosan Lathe) 1-Turn as per Dwg DSK 101 & Folio FC492
 Descriptions: 110 - QC2 Machining-2 (QC2- Inspect parts off machine FAI/FAIB)
 120 - HAAS1-3 (HAAS CNC Vertical Machine) 1-Machine as per Folio FA627 & Dwg D3488
 130 - QC2 Machining-2 (QC2- Inspect parts off machine FAI/FAIB)
 140 - QC8 Machining-2 (QC8- Inspect parts - second check)
 150 - HandFinish1 (Chemical Conversion Coat per QSI005 4.1)
 160 - Powdercoat1 (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: 12:40 OVEN TEMPERATURE: 320° FINISH TIME: 1:10 M/193459.
 170 - QC3 (QC3- Inspect Part Finish)
 200 - Packaging3-1 (Identify as per dwg & Stock Location: FP001 LOCATION : FP001)
 210 - QC21 (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D6103-003	Round Billet, Aluminum	12 pcs (1 ea)	100-Doosan - 1	3190814 X12

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Doosan - 1	D6103-003	12	26	0

Part Specifications	
Specifications could not be found.	

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only

NCR No.

Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Eng. (Non-AW) ☐ Engineering ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Water Jet ☐ Large Fab ☐ Finishing ☐ Rec/Store/Packaging ☐ Supplier ☐ Quality ☐																															
Date :	Sequence #:	QTY Affected :		MRB (QS1042)																															
Description Work Order Deviation		Disposition																																	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY <table border="1"> <tr> <td>Pressure/Forced</td> <td>Contamination</td> <td>Power Loss/Surge</td> <td>Positioned Wrong</td> </tr> <tr> <td>Bending</td> <td>Misaligned/off center</td> <td>Folio/Program</td> <td>Outside Tolerance</td> </tr> <tr> <td>Crushing</td> <td>BOM/Route</td> <td>Grain Direction</td> <td>Drawing</td> </tr> <tr> <td>Cracks</td> <td>Broken/Damage/Defect</td> <td>Weld</td> <td>Finish</td> </tr> <tr> <td>Crimp/Kink/Ripple/Wave/Twist</td> <td>Incomplete/Unclear Instructions</td> <td>Wrong Stock Pulled</td> <td>Part Lost/Missing</td> </tr> <tr> <td>Marks/Chatter</td> <td>Drill Holes</td> <td>Out of Sequence</td> <td>Misread</td> </tr> <tr> <td>Mislabeled</td> <td>Fit/Function</td> <td>Off-set/Set-up</td> <td></td> </tr> </table>						Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong	Bending	Misaligned/off center	Folio/Program	Outside Tolerance	Crushing	BOM/Route	Grain Direction	Drawing	Cracks	Broken/Damage/Defect	Weld	Finish	Crimp/Kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled	Part Lost/Missing	Marks/Chatter	Drill Holes	Out of Sequence	Misread	Mislabeled	Fit/Function	Off-set/Set-up	
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